

Date: Wednesday, 1/31/2007 3:52:08 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PLUG
Job Number :	30569		
Estimate Number :	12337		
P.O. Number :	N/A	Part Number :	D3492043
This Issue :	1/31/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3492 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	29984	Drawing Revision :	B
		Material :	N/A
		Due Date :	2/15/2007
Written By :	Qty: 40 Um: Each		
Checked & Approved By :	J 02.02.01		
Comment :	Est Rev: A 06.03.21 New Issue JLM Est Rev: B 06-08-28 As per Rev B JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0 f(s)/Unit Total : 3 f(s) 6.75'
 6061-T6 Round Bar .750"
 (M6061T6R750)
 Batch: M103156

DJP 07/04/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492
 Dwg Rev: B
 Folio Rev: B

DJP 07/04/14 (123)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/04/14 (123)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 07/04/14 123

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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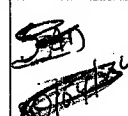
Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07/04/14 (123)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 3:52:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 30569

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

F&L

07/04/26

(123)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

HL

0705-00

(123)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F&L

07/05/03

(123)

9.0

NAS1611013

O-RING



Comment: Qty.: 1 Each(s)/Unit Total: 40 Each(s)

Qty Part Number Description
1 NAS1611-013 O-RING

Batch
B103500

F&L

07/05/03

(123)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492, Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: M101223

F&L

07/05/03

(123)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 070510

(123)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP-16

M-L

07/05/10

(123x)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/11

(123)

Job Completion



U 07.05.11

Dart Aerospace Ltd

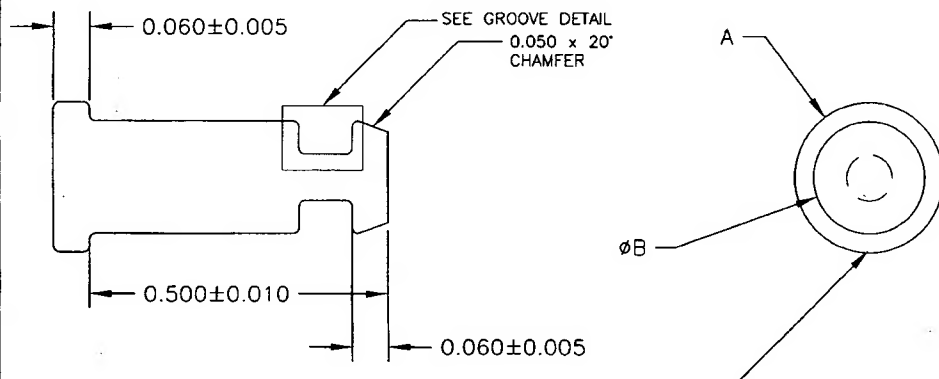
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

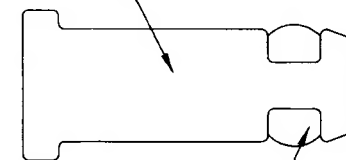
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1

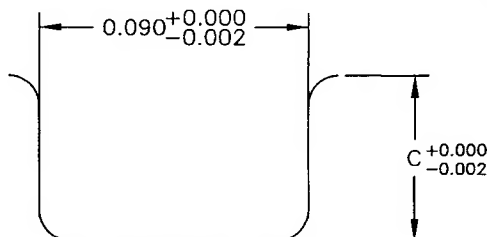
D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED
06.10.03 PH
P/N 6061T6R0.500



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500



D3492-1/-3/-5/-7 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

NO. 30569
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING

B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.05.11	TITLE
		PLUG
		SCALE
		NTS

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DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3492 REV. B SHEET 1 OF 1